

Date: Thursday, 06/11/2008 2:22:45 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 43243		
Estimate Number	: 13644		
P.O. Number	:	Part Number	: D32345
This Issue	: 06/11/2008 S.O. No. :	Drawing Number	: D3234 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>W</u>	Due Date	: 07/11/2008
Checked & Approved By	: <u>W</u>	Qty:	12 Um: Each
Comment	: Est Rev:A New Issue 08-11-06 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S050	5052-H32 .050 Sheet
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Comment: Qty.: 0.0231 sf(s)/Unit Total : 0.2772 sf(s)  
5052-H32 .050 Sheet  
BATCH: 14050 HB 8-11-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D 3234  
Dwg Rev: A  
Prog Rev: A

HB 8-11-7

24

2-Deburr if necessary

1 08/11/10 24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-11-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Solution counter +24

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M-L 08/11/11

24

WO:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

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Drawing Name: SPACER

Job Number: 43243

Part Number: D32345

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*P. J. 8/11/11*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*P. J. 8/11/11*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/11/11*

Comment: FINAL INSPECTION/W/O RELEASE

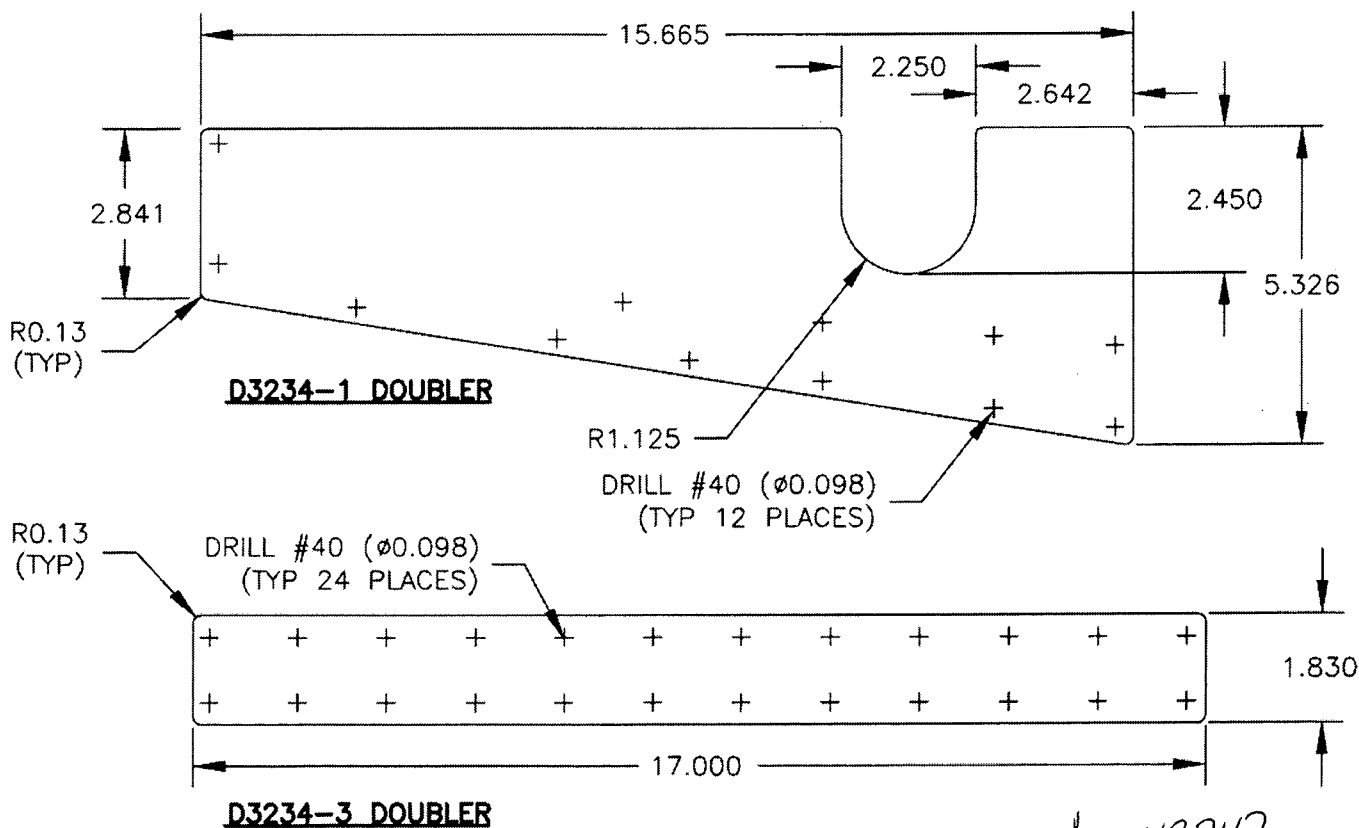
Job Completion



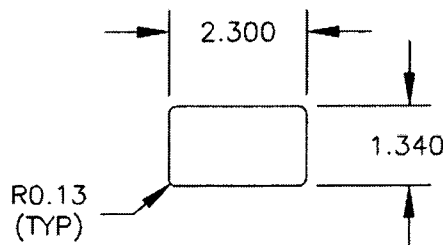
*MF 08-11-11*



DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JP</i>	APPROVED <i>JP</i>	DRAWING NO. D3234	REV. A SHEET 1 OF 1
DATE 03.11.19		TITLE DOUBLER	SCALE 1:3
A	03.11.19	NEW ISSUE	



RELEASED  
03.11.24 *JP*



*w/o 43243*

**D3234-1/-3 DOUBLER. D3234-5 SPACER**

- 1) MACHINE PARTS PER DWG FILE "D3234-A.DWG"
- 2) MATERIAL: -1/-3: 2024-T3 (QQ-A-250/4), 0.050 THICK (REF DART SPEC. M2024T3S.050)  
-5: 5052-H32 (QQ-A-250/8), 0.050 THICK (REF DART SPEC. M5052H32S.050)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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